

Work Order ID 81474

81474

Page 1

Wednesday, March 14, 2012 2:32:40 PM

Item ID: D3910-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Lug
 Start Date: 3/14/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 3/31/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 12-03-14 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3910	B								

100 0.00
100
 Bandsaw Memo 0.00 CZ 12/03/15
 Jeaspa Bandsaw CUT BLANK 1.450" LONG
cut @ meter

110 0.00
110
 HAAS 1 punch Memo 0.00 CZ 12/03/15 40
 HAAS CNC vertical machine #1 MACHINE AS PER FOLIO FA865 AND DWG
 FOLIO REV: #1
 DWG REV: P/O: 16451

DEBURR issue p/b to meter
machine as per dwg D3910 REV.B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Wednesday, March 14, 2012 2:32:40 PM

81474

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 3/14/2012 **Start Qty:** 40.00

40

Cust Item ID:

Required Date: 3/31/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

~~120~~ *rec'd*
~~*120*~~

~~QC2- Inspect parts off machine FAI/FAIB~~

0.00

QC
Quality Control

Memo

0.00

rec'd + inspect for transit damage.
attached cofc to W/O

130
130

QC8- Inspect parts - second check

0.00

QC
Quality Control

Memo

0.00

140
140
HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish
Hand Finishing

Memo

0.00

Conto
438

38 ~~ALD~~ 4-2.

W/O:		WORK ORDER CHANGES					
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Work Order ID 81474***81474***

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Item ID: D3910-1

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Lug

Stop ***NS2***

Start Date: 3/14/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 3/31/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

S-1h10
T-320°F
F-1h40

0.00

M 120 222

38

DP

12/04/03

Powder Coating

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

38

PK

12-14-3

Quality Control

170

Identify as per dwg & Stock Location: 507

0.00

170

Packaging

Memo

0.00

12/14/3

J

38A

Packaging

W/O:		WORK ORDER CHANGES					
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Work Order ID 81474***81474***

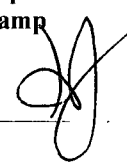
Page 4

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QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/4/4 

112-044

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 14, 2012 2:32:40 PM

Page 1

Work Order ID: 81474

Parent Item: D3910-1

Parent Item Name: Crosstube Lug

Start Date: 3/14/2012

Required Date: 3/31/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
03-23 JLM VERIFIED BY:DD

IPP REV:B AS PER REV B 10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 Lug Extrusion		Manufactured	No			100	f	321.6600	0.13	54736842			

CS 12/03/15

Location

Loc Qty

Loc Code

MAT006

321.66

43722

161.5

45800

1

68331

159.16

548

D3910-1P

6/23/23/40

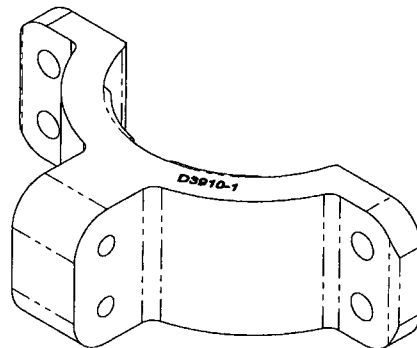
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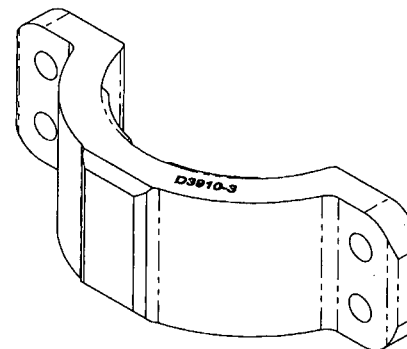
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D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

#81474

RELEASED
2010-03-22
MD

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-007-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED	[Signature]	DRAWING NO.	REV. B	
MFG. APPR.	[Signature]	D3910	SHEET 1 OF 3	
APPROVED	[Signature]	TITLE	SCALE	
DE APPR.	[Signature]	X-TUBE LUG (350)	NTS	
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>		

W/O:		WORK ORDER CHANGES					
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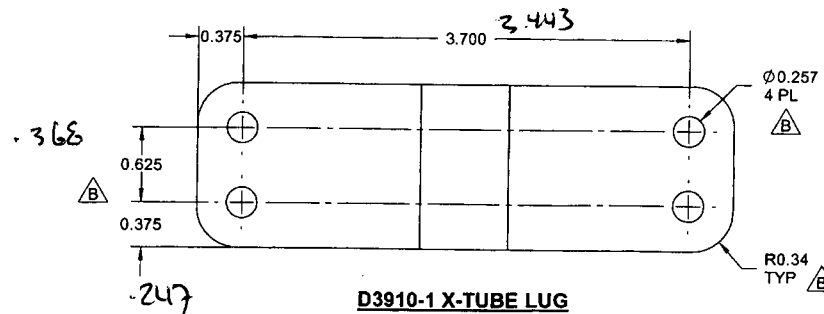
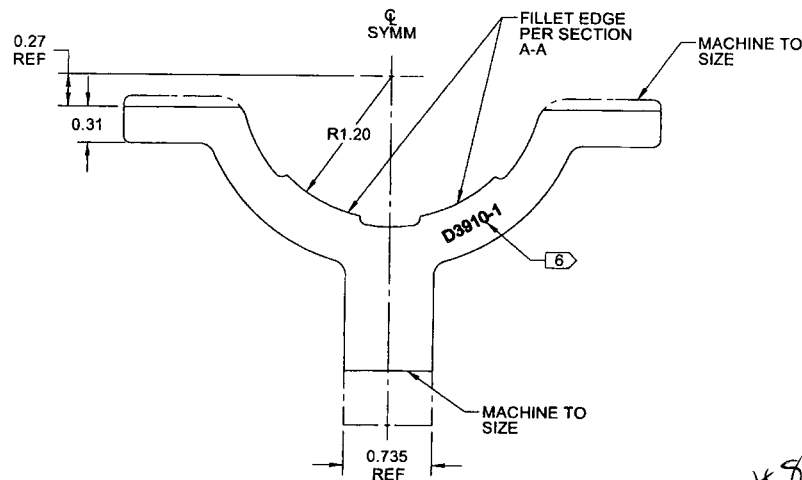
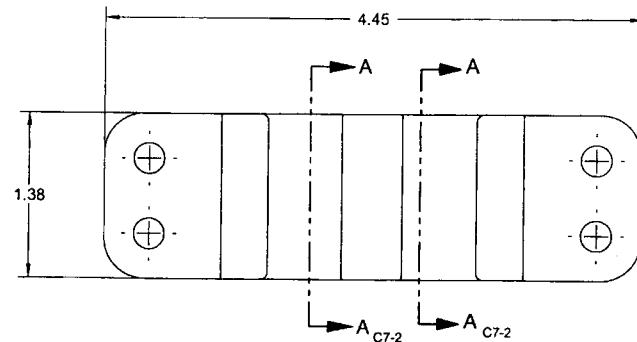
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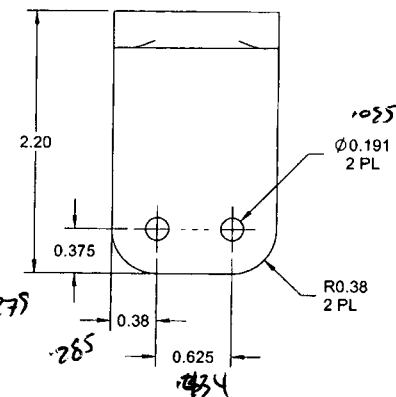


ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2



D3910-1 X-TUBE LUG



RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. D3910	REV. B SHEET 2 OF 3
MFG. APPR.		TITLE X-TUBE LUG (350)	SCALE NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.03.16		

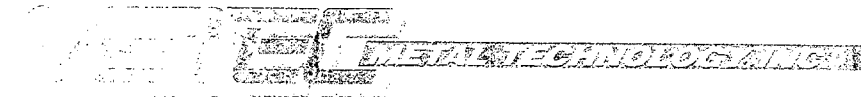
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18483
Date: Mar 23, 2012
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO16451	Sold By: Dewar, Eric
Shipped By: our truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3910-1 Crosstube Lug as per drawing D3910 REV.B B81474	Each	40	40	
D2230-3 Mounting Lug as per drawing D 2230 REV.G B81558	Each	200		200
D4091-1 Lug as per drawing D4091 Rev.AB81461	Each	30		30
3910-3 Crosstube Lug as per drawing D3910 REV.B B81459	Each	40		40
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

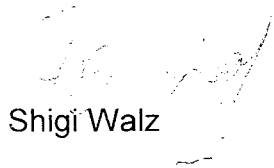
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
40	D3910-1	Lug	16451

MATERIAL: supplied by DART B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.



Shigi Walz

Vankleek Hill, March 22, 2012



Invoice No.: 9022
Date: Mar 23, 2012
Page: 1

Dart Aerospace Ltd.
 Att. Linda Lacelle
 1270 Aberdeen Street
 Hawkesbury, Ontario K6A 1K7

Shipping Address
 Dart Aerospace Ltd.
 Att. Linda Lacelle
 1270 Aberdeen Street
 Hawkesbury, Ontario K6A 1K7

P.O. Number PO16451		Shipped by our truck Delivery Slip #: 18483		Terms: 2%/10, Net 30. Due Apr 22, 2012.		
Description	Quantity ordered	Quantity shipped	Quantity on B/O	Unit	Unit Price	Amount
D3910-1 Crosstube Lug as per drawing D3910 REV.B B81474	40	38		Each	31.55	1,198.90
D2230-3 Mounting Lug as per drawing D 2230 REV.G B81558	200		200	Each	13.60	
D4091-1 Lug as per drawing D4091 Rev.AB81461	30			Each	26.95	
3910-3 Crosstube Lug as per drawing D3910 REV.B B81459	40			Each	31.55	
Subtotal:						1,198.90
H - HST 13%						
HST						155.86
Thank you for your order! HST # 867 061 723 RT0001 Interest on overdue accounts is charged at 24% per year						
Total in CAD						1,354.76

8/2/12



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

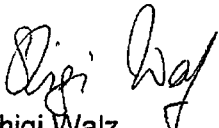
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
38	D3910-1	Crosstube Lug	16451

MATERIAL: supplied by DART B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, March 23, 2012